

Work Order ID 70431

Wednesday, June 08, 2011 8:08:17 AM



Page 1

Item ID: D3212-1B
Revision ID: PRELIM
Item Name: Floor Window

Accept



Setup Start



Stop



Start Date: 6/9/2011 Start Qty: 1.00
Required Date: 6/10/2011 Req'd Qty: 1.00



Cust Item ID:
Customer:

PRELIMINARY ISSUE

Reference:

Approvals: Process Plan: umf Date: 11-06-06 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3212	PC1 <u>C</u> <u>HA</u>								
100	FLOW WATER JET	0.00							
	Waterjet								
FLOW CNC Waterjet	Memo	0.00							
<u>1/8 play</u>	1-Cut blankas per Dwg D3212 <input type="checkbox"/> Dwg Rev: <u>PC1</u> <input type="checkbox"/> Prog Rev: <u>PC1</u>								
	<input type="checkbox"/> 2-Deburr if necessary								
120	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC								
Quality Control	Memo	0.00							
130	QC8- Inspect parts - second check	0.00							
	QC								
Quality Control	Memo	0.00							

- inspected to PC1
Dwg only.
Subtotal 60

B11-6-8①B11-6-8

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Stop

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

140



Small Fab

Small Fab

Small Fab

Memo

1-Deburr if necessary

2-Install label as per Dwg D3212

3- polish abrasion scratches if necessary.

4-Wrap in plastic wrap after inspection

0.00

0.00

6/5/11/06/09 ①

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

- inspect to 1192

Day only

Don't know

(40)

160



Packaging

Packaging

Identify as per dwg & Stock Location: _____

Memo

0.00

0.00

11/6/11

W/O:		WORK ORDER CHANGES						
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Setup Start



Stop



Cust Item ID:

Customer:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/15 *[Signature]*

POSITIVE RECALL

EFFECTIVE

AUTH

RELEASED

DATE

MF
11-06-14*[Signature]*
[Signature]
11/6/14

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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NOTE: Date & initial all entries

Picklist Print

Wednesday, June 08, 2011 8:08:14 AM

Page 1

Work Order ID: 70431



Parent Item: D3212-1B



Parent Item Name: Floor Window

Start Date: 6/9/2011

Required Date: 6/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP revA 11.06.07 New issue EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MACRLICS.125		Purchased	No			100	sf	288.9934	0.96	1.010526			



1/8" Polycast II Sheet

B11-6-9

Location

Loc Qty

Loc Code

MAT

142.2467

117431

142.2467

MAT018

142.2467

117324

68.7667

117340

73.48

MAT019

4.5

115338

4.5

115339

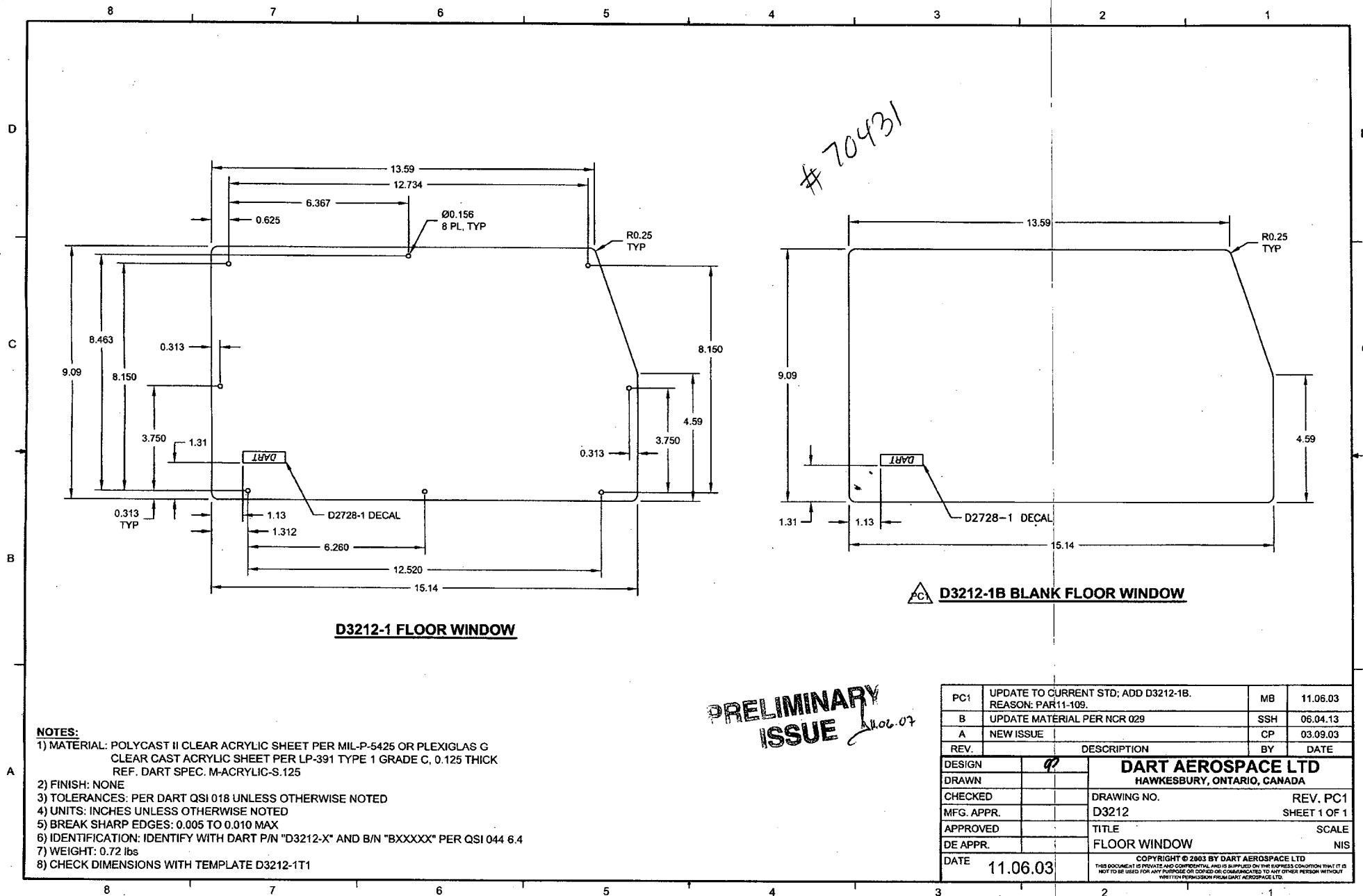
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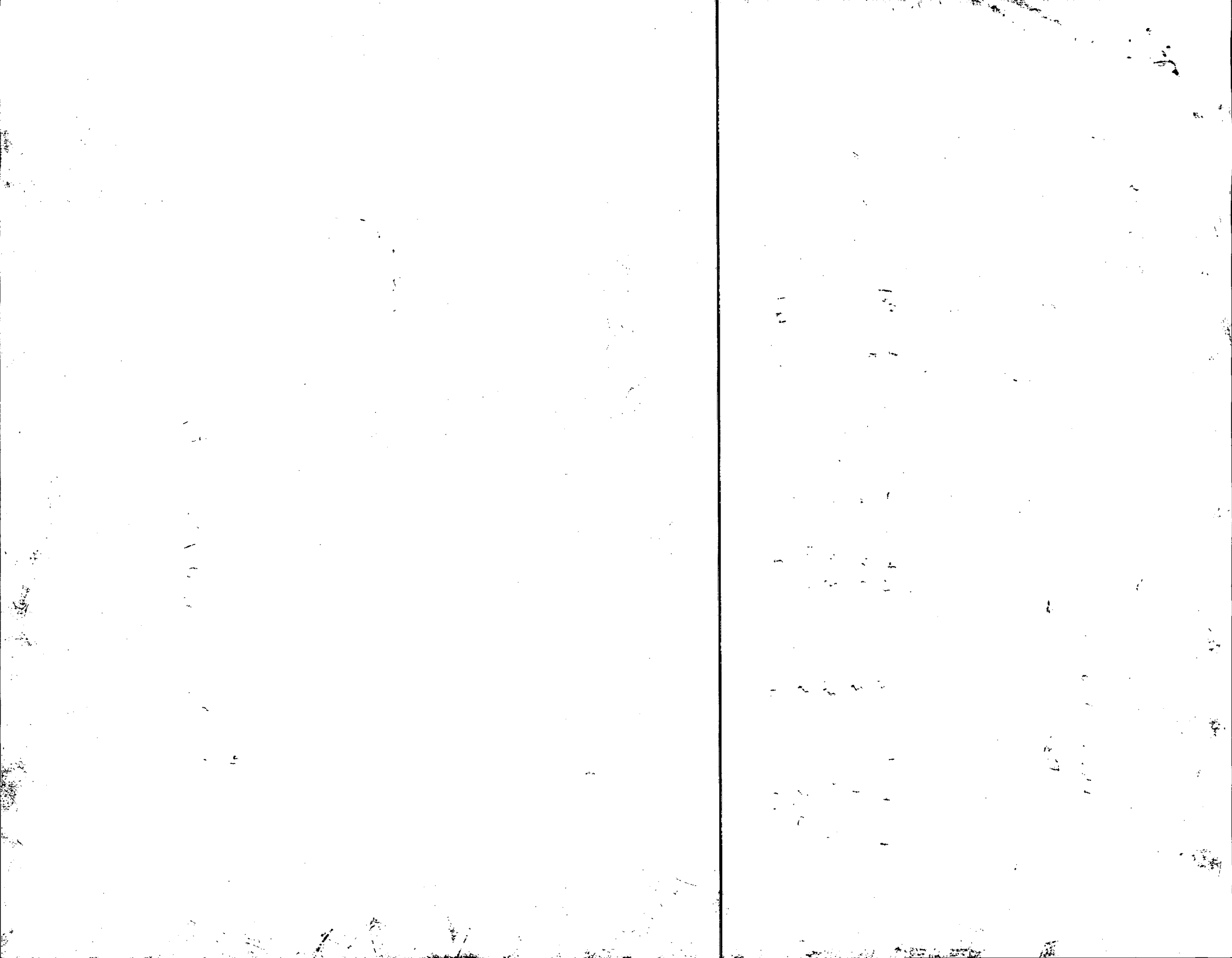
NOTE: Date & initial all entries

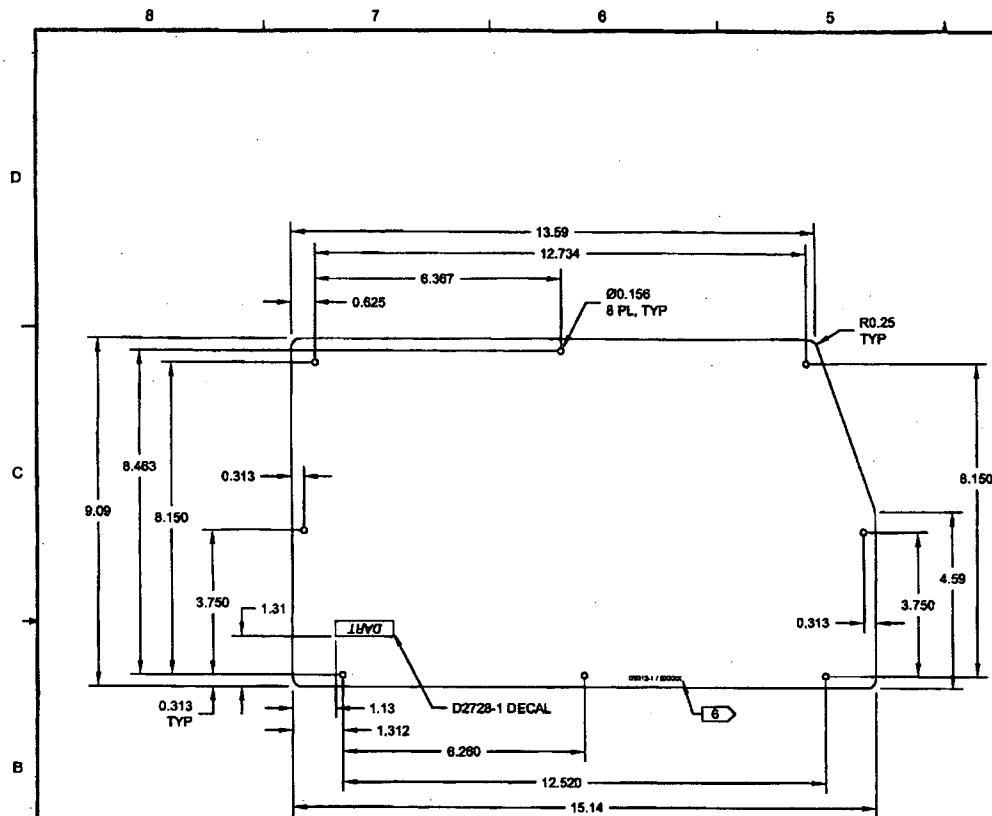
FIRST ARTICLE INSPECTION CHECKLIST

x	Prototype
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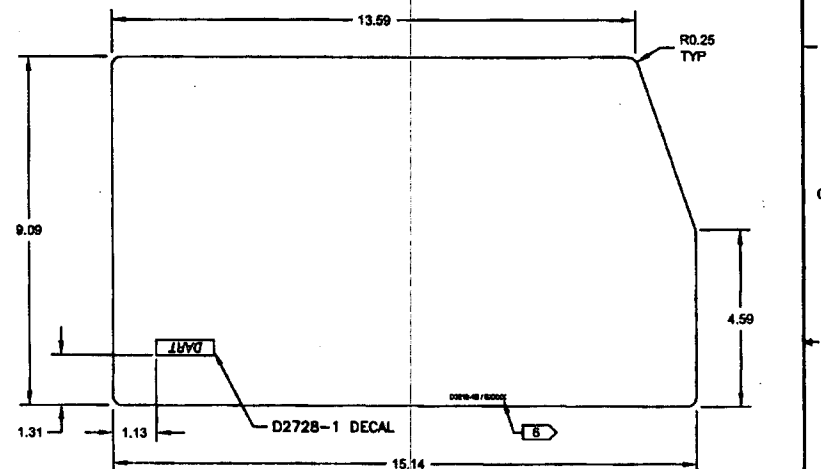
Measured by: B	Audited by: S	Prototype Approval:
Date: 11-6-8	Date: 11/6/08 for PC/PM on 1/4	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	





D3212-1 FLOOR WINDOW



D3212-1B BLANK FLOOR WINDOW

NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425 OR PLEXIGLAS G
CLEAR CAST ACRYLIC SHEET PER LP-381 TYPE 1 GRADE C, 0.125 THICK
REF. DART SPEC. M-ACRYLIC-S.125
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3212-X" AND B/N "BXXXXX" PER QSI 044 8.4
WITHIN 0.50 FROM EDGE
- 7) WEIGHT: 0.72 lbs
- 8) CHECK DIMENSIONS WITH TEMPLATE D3212-1T1

70431

RELEASED
2011-06-16
MP

C	UPDATE TO CURRENT STD; ADD D3212-1B. REASON: PAR11-109.	MB	11.06.03
B	UPDATE MATERIAL PER NCR 029	SSH	06.04.13
A	NEW ISSUE	CP	03.09.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.03		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D3212
TITLE FLOOR WINDOW
REV. C
SHEET 1 OF 1
SCALE NIS

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